

Date: Wednesday, 09/04/2008 9:18:31 AM  
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 38505  
Estimate Number : 13098  
P.O. Number :  
This Issue : 09/04/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : THERMOFORMING  
Previous Run : 37665  
Written By :  
Checked & Approved By : JB 08.4.09  
Comment : Est. Rev. A 07/12/13 DL verified by:DD

Drawing Name : PANEL-350 AFT CANOPY  
Part Number : D36561  
Drawing Number : D3656 REV A  
Project Number : 00204  
Drawing Revision : A  
Material :  
Due Date : 30/04/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MLEXS093F600607 GE PLASTICS LEXAN SHEET



Comment: Qty.: 23.0000 sf(s)/Unit Total : 46.0000 sf(s)  
GE PLASTICS LEXAN SHEET  
batch: M105494

PTO

JB 08/04/09 X2

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

JB 08/04/09 X2

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-1and Folio FTA 015 using tool DT 8986

Dwg. Rev. A  
Folio Rev. A

JB 08/04/10 X2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

JB 08/04/10 X2

Dart Aerospace Ltd

W/O: 38505		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.04.10	1	change material usage to 32.88 ft. to remove 6ft over, unusable material from stock (correct estimate) #13098 Permanent change	DL	08.04.10			<i>[Signature]</i> 08.04.10

Part No: D 3650-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: 09/04/2008 9:18:31 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 38505

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



08/04/11 Dh  
x2

Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



08/04/11 Dh

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

x2

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08/04/11 Dh  
x2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



08/04/11 i

Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08/09/16 E

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08.09.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER: 38505
Description: PANEL 350 AFT CANOPY	Part Number: D36561
Inspection Dwg: D3656 Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Tight, even radius throughout part	Ph
Acceptable shape definition	Ph
Acceptable texture retention	Ph
Free of visual flaws (bumps, cracks, voids, etc.)	Ph

### (Step 6) Trimming FAI Checklist

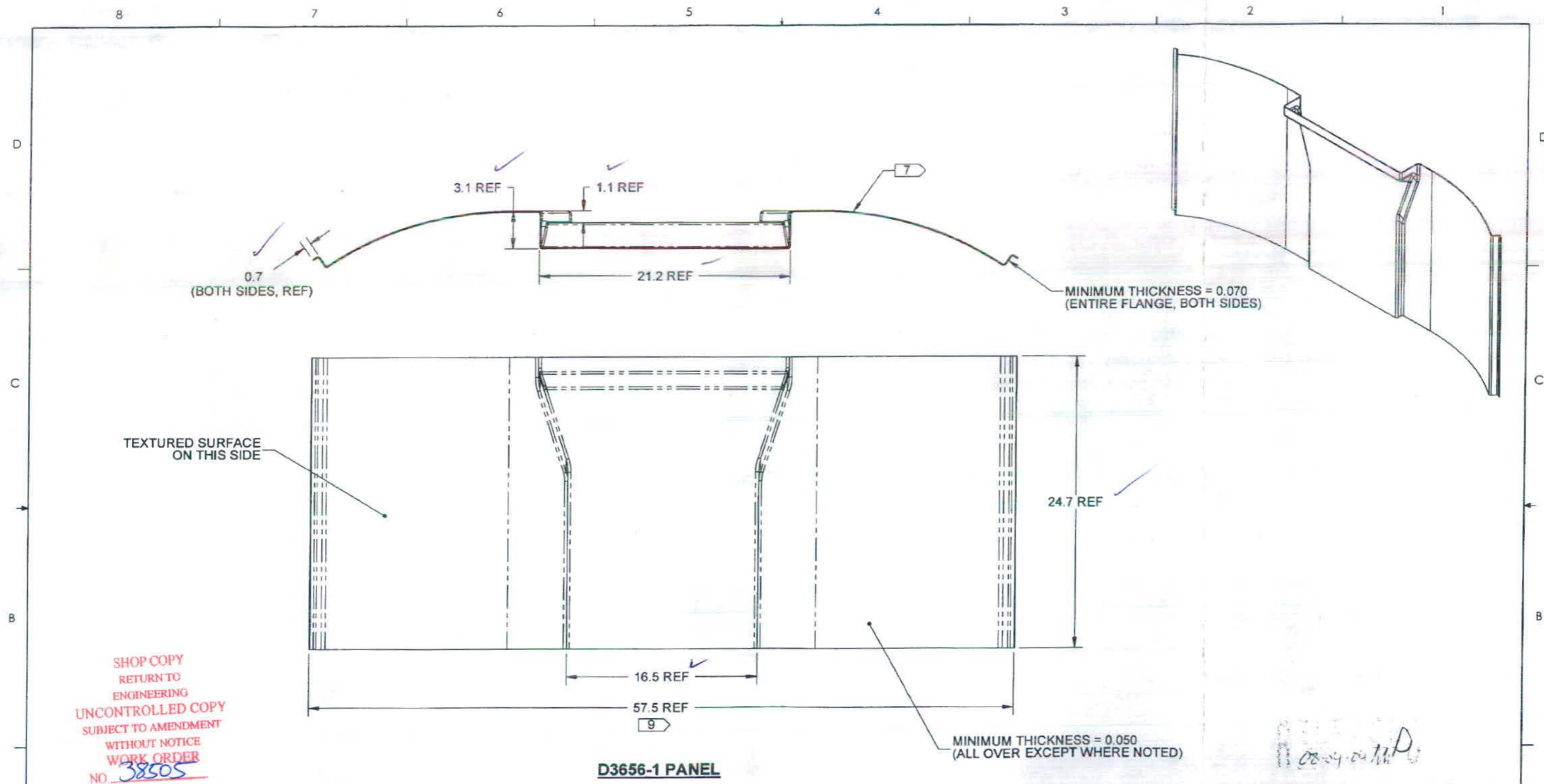
Inspect dimensions highlighted on inspection sheet drawing D36561 Rev. A and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.7	.1	24.7	✓		Tape	1 side gaged, other
0.070	MIN.	0.083	✓		Vern	slightly long but gets
0.050	min	0.063	✓		Vern	trimmed to fit by customer

Measured by: Ph	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 08.04.10	Date: 08.04.10	Date: 08.04.10

Rev	Date	Change	Revised by	Approved
		New Issue		





# NOTES:

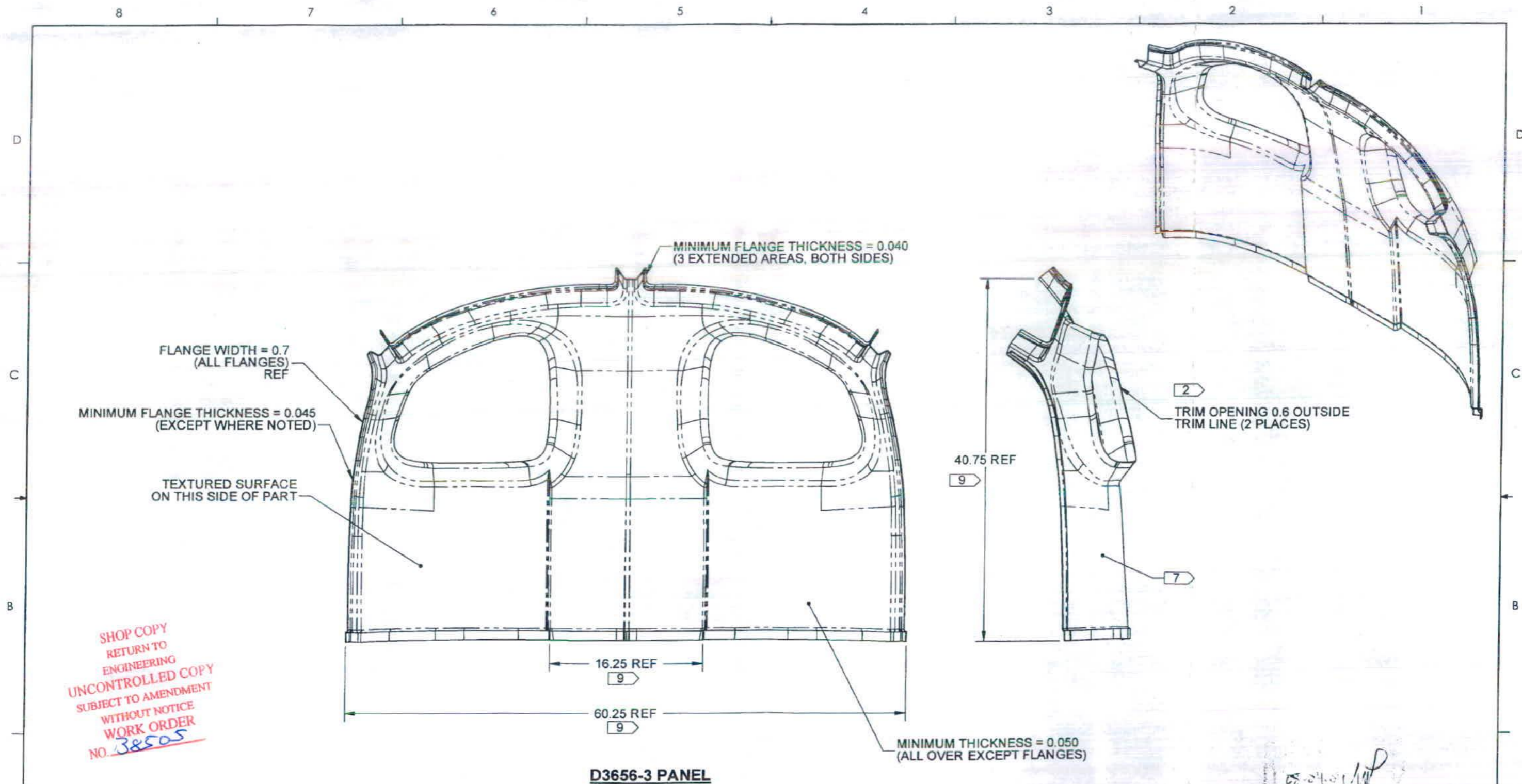
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022  
TRIM PER MOLD DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	LE	08.03.03
DESIGN	LE		
DRAWN	LE		
CHECKED	RA		
MFG. APPR.	RA		
APPROVED	MP		
DE APPR.	MP		
DATE	08.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D3656	SHEET 1 OF 2
TITLE PANEL	SCALE NTS

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**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022  
TRIM PER MOLD DT8987 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR.	WHP	D3656	SHEET 2 OF 2
APPROVED	WHP	TITLE	SCALE
DE APPR.	WHP	PANEL	NTS
DATE	08.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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